



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB H4713
Job Sheet 173190



Part No: RB H4713

Job Qty: 2 ea

Part Name: Drain Hose



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB H4713 Rev 4 IPP Rev A 18.02.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		3/8/18	0.00	0.00	Start Up Small Fab-4		MCC
100	Small Fab	2 pcs		3/9/18	0.00	0.25	Small Fab-9		MCC DAG
110	QC	2 pcs		3/9/18	0.00	0.00	QC5		38
130	Packaging	2 pcs		3/9/18	0.00	0.00	Packaging3-2		GA074 18-06-04
140	QC21-FG	2 Ea		3/9/18	0.00	0.00	QC21		DAG 21 9-09

Part Op 100 - Assemble and pack as per DWG.
Descriptions: 130 - Identify and Stock

JUN 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2044T47	Tube Ø1.09	.7000 ft (.35 ea)	90-Start up Operation	5016490
2044T67	Cap Ø1.09	4 Ea (2 ea)	90-Start up Operation	5051497
51495K116	COUPLING 1/2" NCKL PLTD BRASS PUSH TO CONNECT TUBE FITTING COUPLING	2 Ea (1 ea)	90-Start up Operation	5059522
K010-0608	Hose Ø1/2 OD x Ø3/8 ID x 12-1/2ft	12 ft (6 ea)	90-Start up Operation	5053844
PAD210	Foam Ø1 X 1	.0140 sf (.007 ea)	90-Start up Operation	5021250
RB H4713-1	Drain Hose Body	2 Ea (1 ea)	90-Start up Operation	5070398
9263K642	O-Ring	2 Ea (1 ea)	90-Start up Operation	5009624

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	2044T47	1	36	0
	2044T67	4	40	0
	51495K116	2	28	0
	9263K642	2	17	0
	K010-0608	12	208	0
	PAD210	0	15	0
	RB H4713-1	2	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ /Packaging Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																										
Description DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S077025 Part: RB H4713 Job No: 173190 Serial No/Batch: S077025 Revision: 4 Inspector: _____ Exp Date: 06/01/2018 Instructions: _____ Date: 06/01/18		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																										
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Part Specifications

Specifications could not be found.

Plex 2/26/18 3:56 PM Dart.lajeunesse.marie

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WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

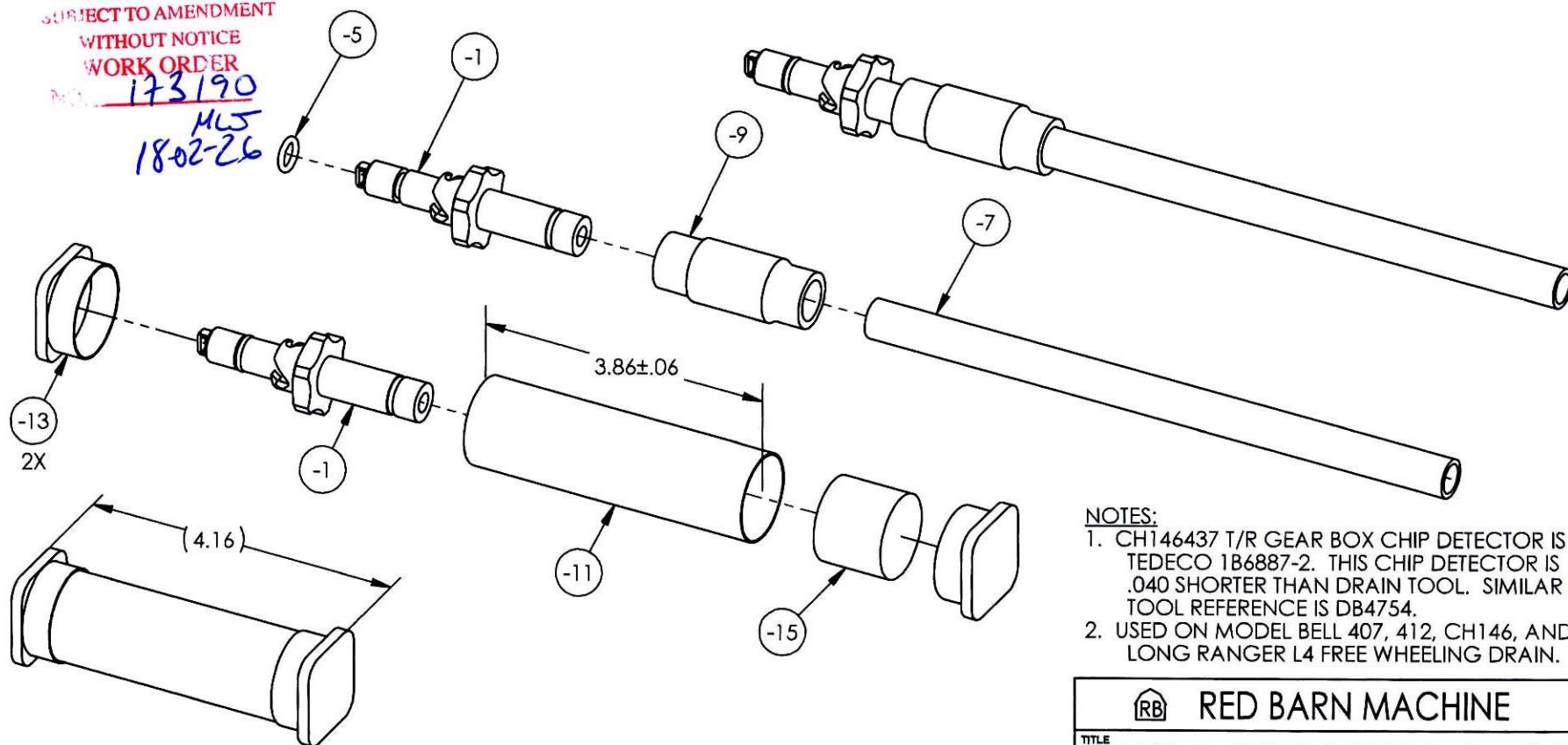
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Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	Past Due ☐					

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CHANGED HOSE LENGTH FROM 24 in. to 6 ft.	4/15/08	WP	RW
2	DELETED -3 COLLAR, & ADDED -9 CLAMP. REFORMATED DIMENSIONS, ADDED NEW DRAWING FORMAT AND ASSY VIEW.	5/20/08	WP	RW
2A	ADDED NOTES & CH146 TO MODELS USED ON. ALSO ADDED ALTERNATIVE O-RING. ADDED -11 SHRINK WRAP & MARK TOOL NO.	8/10/09	WP	DW
2B	ADDED LONG RANGER INFO IN MODEL USED ON	12/3/09	WP	DW
2C	CH'D TOOL NUMBER FROM H4713 TO RB H4713	10/7/10	RJC	RW
3	MODIFIED -1 TO USE WITH COUPLING, ADDED COUPLING & SPONGES. REMOVED HOSE CLAMP & SHRINK WRAP. ADDED -13, -15, -17, EXPLODED VIEWS, UPDATED BOM. INCREASED STEM LENGHT FROM .80 TO 1.35, REMOVED BARB ADDED GROOVE.	7/24/2012	JAG	SE
4	-1 CH'D ANGLE OF LOCK GROOVES SEAT WAS 60° IS 90°. CH'D DIM'S WAS .125 IS .125 +.005 -.000 $\sqrt{.090}$, WAS $\varnothing 2.50 \sqrt{3.07}$ IS $\varnothing 2.50 \sqrt{3.07}$ MAX; DELETED 6X .11, (.244), (.096). ADDED NOTES WAS .50 IS .50 NO ENGRAVING, CH'D DIM WAS 6X R.38 IS 6X R.38 EQUALLY SPACED ON $\varnothing 1.60$ B.C., CH'D NOTE WAS ENGRAVE T/N IS ENGRAVE T/N, S/N, "MADE IN USA". -11 LENGTH FROM 3.97 TO 3.86. -15 CH'D MATERIAL WAS MCMASTER-CARR #7271T32 IS NEW PIG CORP. #PAD210.	2/12/14	DPD	GE

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173190
MLJ
1802-26



NOTES:

- CH146437 T/R GEAR BOX CHIP DETECTOR IS TEDECO 1B6887-2. THIS CHIP DETECTOR IS .040 SHORTER THAN DRAIN TOOL. SIMILAR TOOL REFERENCE IS DB4754.
- USED ON MODEL BELL 407, 412, CH146, AND LONG RANGER L4 FREE WHEELING DRAIN.



RED BARN MACHINE

TITLE			
TRANS. & GEAR BOX DRAIN TOOL			
DWG NO.		RB H4713	REV 4
MAT'L	DRAWN BY: ROBERTS		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>	
.XXX ± .005 FRACTIONS ± 1/32		REAT	
.XX ± .01 ANGLES ± 5°		TREAT	
.X ± .1		FINISH	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		SPEC	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL	
		NOTE 2	
SCALE	1:2	DATE	8/29/2000
		SHEET 1 OF 2	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BODY	6061	$\varnothing 1-1/8 \times 3-1/4$	2
		B/O	-5	1	O-RING	VITON	2-011N70 OR MCMASTER-CARR #9263K642	1
		B/O	-7	1	HOSE	VINYL	$\varnothing 1/2$ O.D. x $\varnothing 3/8$ I.D. x 6ft KURI-TECH #K010-0608	1
		B/O	-9	1	COUPLING	NICKEL-PLATED BRASS	$\varnothing 1/2$ MCMASTER-CARR #51495K116	1
		B/O	-11	1	TUBE	POLYETHYLENE	$\varnothing 1.09$ MCMASTER-CARR #2044T47	1
		B/O	-13	2	CAP	VINYL	$\varnothing 1.09$ MCMASTER-CARR #2044T67	1
		B/O	-15	1	FOAM	POLYESTER/POLYURETHANE	$\varnothing 1 \times 1$ NEW PIG CORP. #PAD210	1

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